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D2721-041
Job Sheet 208449



Part No: D2721-041

Job Qty: 4 pcs

Part Name: 206B Step Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/20/20

Job Tracking No:

Due Date: 4/13/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP Rev:F As Per Ecn 766 06-01-06 JLM IPP Rev:G add wing walk DD 10.02.24 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Steps - 1	4 pcs			0.00	7.60	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	Large Fab - Steps - 2 - B4B	4 pcs			0.00	4.00	Large Fab - 1 - B4B		DAS 24 9-89
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		
							Large Fab - 7 - B4B		
							Large Fab - 8 - B4B		
							Large Fab - 9 - B4B		
							Large Fab - 11 - B4B (Various)		
							Large Fab - 12 - B4B		
120	QC 9	4 pcs			0.00	0.00	QC 9 - 10		DAS 43 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		

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130 QC 5	4 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	DAS
			QC 5 - 43	43
			QC 5 - 49	9-89
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
140 Handfinish - 1-1 Chemical-B4B	4 pcs	0.00 0.90	Handfinish - 1 - 1 - B4B	BEB 20-04-02
			Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	
			Handfinish - 1 - 22 - B4B	
150 QC 7	4 pcs	0.00 0.00	QC 7 - 10	
			QC 7 - 13	
			QC 7 - 14	
			QC 7 - 15	DAS
			QC 7 - 17	24
			QC 7 - 18	9-89
			QC 7 - 19	
			QC 7 - 2	
			QC 7 - 28	
			QC 7 - 3	
			QC 7 - 30	
			QC 7 - 34	
			QC 7 - 36	
			QC 7 - 37	
			QC 7 - 41	
			QC 7 - 47	
			QC 7 - 48	
			QC 7 - 51	

			QC 7 - 58	
			QC 7 - 59	
			QC 7 - 60	
			QC 7 - 9	
			QC 7 - 68	
			QC 7 - 50	
			QC 7 - 67	
			QC 7 - 40	
			QC 7 - 24	
			QC 7 - 43	
			QC 7 - 61	
			QC 7 - 81	
			QC 7 - 76	
			QC 7 - 79	
			QC 7 - 83	
			QC 7 - 82	
160 Large Fab - Steps - 3 - B4B	4 pcs	0.00 7.60	Large Fab - 1 - B4B	<i>SL</i>
			Large Fab - 10 - B4B	
			Large Fab - 2 - B4B	
			Large Fab - 3 - B4B	
			Large Fab - 4 - B4B	
			Large Fab - 5 - B4B	
			Large Fab - 6 - B4B	
			Large Fab - 7 - B4B	
			Large Fab - 8 - B4B	
			Large Fab - 9 - B4B	
			Large Fab - 11 - B4B (Various)	
			Large Fab - 12 - B4B	
170 QC 10	4 pcs	0.00 0.00	QC 10 - 10	
			QC 10 - 18	
			QC 10 - 24	
			QC 10 - 43	DAS
			QC 10 - 50	24
			QC 10 - 58	9-89
			QC 10 - 9	
			QC 10 - 68	
180 QC 5	4 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	DAS
			QC 5 - 24	24
			QC 5 - 3	9-89
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
190 Handfinish - 1-2- Chemical- B4B	4 pcs	0.00 0.19	Handfinish - 1 - 1 - B4B	<i>BEB20-04-07</i>
			Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	

			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	
			Handfinish - 1 - 22 - B4B	
200 Powdercoat - 1 White Gl(A)- B4B	4 pcs	0.00 0.29	Powdercoat - 1 - B4B	
			Powdercoat - 2 - B4B	
			Powdercoat - 3 - B4B	
			Powdercoat - 4 - B4B	
210 QC 3	4 pcs	0.00 0.00	QC 3 - 10	
			QC 3 - 13	
			QC 3 - 15	
			QC 3 - 17	
			QC 3 - 18	
			QC 3 - 2	
			QC 3 - 28	
			QC 3 - 3	
			QC 3 - 30	
			QC 3 - 34	
			QC 3 - 36	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	
			QC 3 - 59	
			QC 3 - 68	
			QC 3 - 9	
			QC 3 - 40	
			QC 3 - 19	
			QC 3 - 43	
			QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	
			QC 3 - 82	
220 Handfinish - 3-1- WingWalk- B4B	4 pcs	0.00 0.80	Handfinish - 3 - 1 - B4B	
			Handfinish - 3 - 2 - B4B	
			Handfinish - 3 - 3 - B4B	
			Handfinish - 3 - 4 - B4B	
			Handfinish - 3 - 5 - B4B	
230 QC 3	4 pcs	0.00 0.00	QC 3 - 10	
			QC 3 - 13	
			QC 3 - 15	
			QC 3 - 17	
			QC 3 - 18	
			QC 3 - 2	
			QC 3 - 28	

		QC 3 - 3	
		QC 3 - 30	
		QC 3 - 34	
		QC 3 - 36	
		QC 3 - 41	
		QC 3 - 51	
		QC 3 - 58	
		QC 3 - 59	
		QC 3 - 68	
		QC 3 - 9	
		QC 3 - 40	
		QC 3 - 19	
		QC 3 - 43	DAS
		QC 3 - 24	02
		QC 3 - 61	9-89
		QC 3 - 81	
		QC 3 - 82	APR 14 2020
240 Packaging 3-1 - Stock - B4B	4 pcs	0.00 0.00	Packaging 3 - 1 - B4B
			Packaging 3 - 2 - B4B
			Packaging 3 - 3 - B4B
			Packaging 3 - 4 - B4B
			Packaging 3 - 5 - B4B
			Packaging 3 - 6 - B4B
			Packaging 3 - 7 - B4B
			Packaging 3 - 8 - B4B
			Packaging 3 - 9 - B4B
			Packaging 3 - 10 - B4B
			Packaging 3 - 11 - B4B
			Packaging 3 - 12 - B4B
			Packaging 3 - 13 - B4B
			Packaging 3 - 14 - B4B
			Packaging 3 - 15 - B4B
			Packaging 3 - 16 - B4B
			Packaging 3 - 17 - B4B
			Packaging 3 - 18 - B4B
			Packaging 3 - 19 - B4B
			Packaging 3 - 20 - B4B
			Packaging 3 - 21 - B4B
			Packaging 3 - 22 - B4B
			Packaging 3 - 23 - B4B
			Packaging 3 - 24 - B4B
			Packaging 3 - 25 - B4B
			Packaging 3 - 26 - B4B
			Packaging 3 - 27 - B4B
			Packaging 3 - 28 - B4B
			Packaging 3 - 29 - B4B
			Packaging 3 - 30 - B4B
			Packaging 3 - 31 - B4B
			Packaging 3 - 32 - B4B
			Packaging 3 - 33 - B4B
			Packaging 3 - 34 - B4B
			Packaging 3 - 35 - B4B
			Packaging 3 - 36 - B4B
			Packaging 3 - 37 - B4B
250 QC 21 - SA	4 pcs	0.00 0.00	QC 21 - SA - 21
			QC 21 - SA - 70
			QC 21 - SA - 53

Part Op 100 - Fabricate per Drwg - Cut D2721-1 using D2622 extrusion as per Dwg D2721 Deburr and bevel ends for welding
 Descriptions: DRILL VENT HOLE AS PER SECTION A-A

- 110 - Large Fab - Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT10215A followed by Jig DT10215B A/R AL Rod Batch: 139019 Grind end cap welds flush
- 120 - QC9- Inspect visual per QSI004- Fusion Welds
- 130 - QC5- Inspect part completeness to step on W/O
- 140 - Chemical Conversion Coat per QSI005 4.1
- 150 - QC7-Inspect Chemical Conversion Coat
- 160 - Large Fab - Inspect for foreign object per QSI 024 Weld Remaining end cap as per Dwg D2721 BLOCK VENT HOLE USING RIVET AS PER DWG A/R AL Rod Batch: _____ Grind End Cap Welds Flush
- 170 - QC10- Inspect visual per QSI004- ground welds
- 180 - QC5- Inspect part completeness to step on W/O
- 190 - Chemical Conversion Coat per QSI005 4.1
- 200 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____
- 210 - QC3- Inspect Part Finish
- 220 - Wing Walk as per dwg QSI005 4.4 Batch _____
- 230 - QC3- Inspect Part Finish
- 240 - Identify as per dwg & Stock Location: _____
- 250 - QC21- Final Inspection - Work Order Release

#15264

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	4 pcs (1 ea)	100-Large Fab - Steps - 1	5243427
D2734	Step End Plate	4 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	5259367
D3461-1	Mounting Plate	4 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	5265646
D3461-3	Mounting Plate	4 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	5265727
D3461-5	Mounting Plate	4 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	5253018
D3461-7	Mounting Plate	4 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	5253029
MS20601-AD4W2	Rivet	4 Ea (1 ea)	110-Large Fab - Steps - 2 - B4B	5252707
D2734	Step End Plate	4 pcs (1 ea)	160-Large Fab - Steps - 3 - B4B	5259367

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Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Steps - 1	D2622-120C	4	36	0
110-Large Fab - Steps - 2 - B4B	D2734	4	95	0
	D3461-1	4	7	0
	D3461-3	4	3	0
	D3461-5	4	17	0
	D3461-7	4	6	0
	MS20601-AD4W2	4	470	0
160-Large Fab - Steps - 3 - B4B	D2734	4	95	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

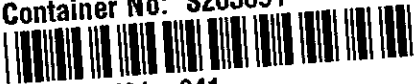
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART
AEROSPACE

Container No: S265891



Part: D2721-041

Job No: 208449

Serial No/Batch: S265891

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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